

Work Order ID 84941

84941

Page 1

May-29-12 1:12:11 PM

Item ID: D3405-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug Assembly

Start Date: 29/05/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/30 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3405

Rev B

30

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B125-30

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-5-30

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8.12.13

cauto
x30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

1-Deburr
2-Form using DT8204 as per Dwg D3405
3- use DT9681 to check if correct forming*SB*
12/06/11
30

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*8.76/12**calc*
30

150

150

Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: *M120013*
Large Fab

0.00

Memo

0.00

Weld as per Dwg D3405 use DT8484
Identify as D3405-043*30**EL 12-7-17*

Dart Aerospace Ltd

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

6/12-7-17

170 QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

DAS 16 17/05/12

waives
830

180 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

180

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:40
400 OF
2:10

30X
12/07/18

M121841

Dart Aerospace Ltd

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Cust Item ID:

Required Date: 16/07/2012 **Req'd Qty:** 30.00

30

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

200 Identify as per dwg & Stock Location:

0.00

200

Packaging

Memo

0.00

Packaging

210 QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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May-29-12 1:12:15 PM

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84941

D3405-043

Required Date: 16/07/2012

Required Qty: 30.00

Comments: IPP A05.09.01New issueKJ/JLM
IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1		Manufactured	No			100	Each	74.0000	1	30			
D3404-1									**			EC 12-7-17	B12-30
GHW Lug													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			74						
				83879			58						
				83983			16						
M304S11GA		Purchased	No			150	sf	124.5700	0.154	4.863158			
M304S11GA									**				B12-5-30
304/316 0.125 Sheet													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				MAT020			124.57						
				121380			29.9						
				121780			94.67						

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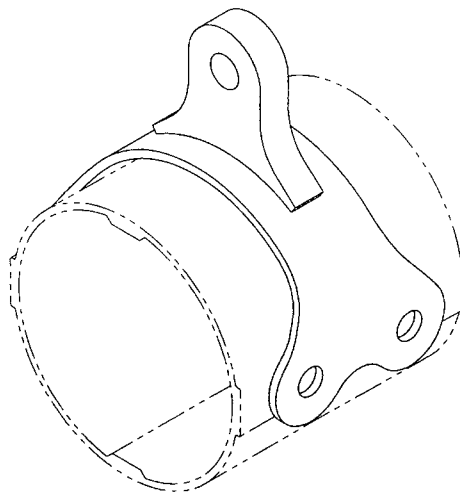
NOTE: Date & initial all entries

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

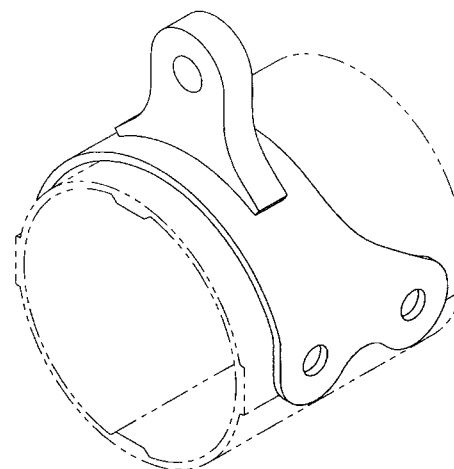
△B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84941 MLC

12/05/30



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/12/18 MLC

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198) SHEETS 3 & 4 ZONE A6 4 120 DIM WAS 4.100	AJS	08.09.19
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO	REV. B
MFG. APPR.		D3405	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

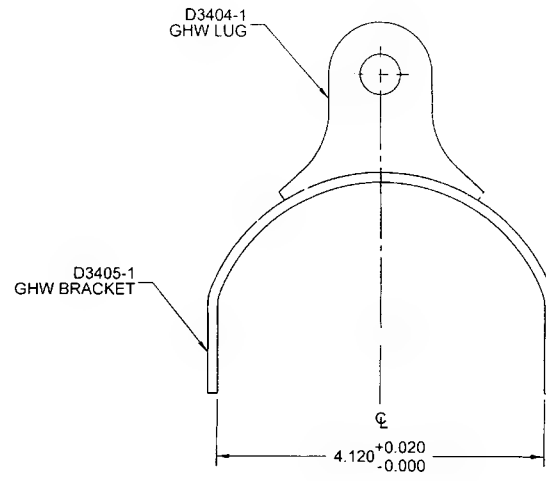
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

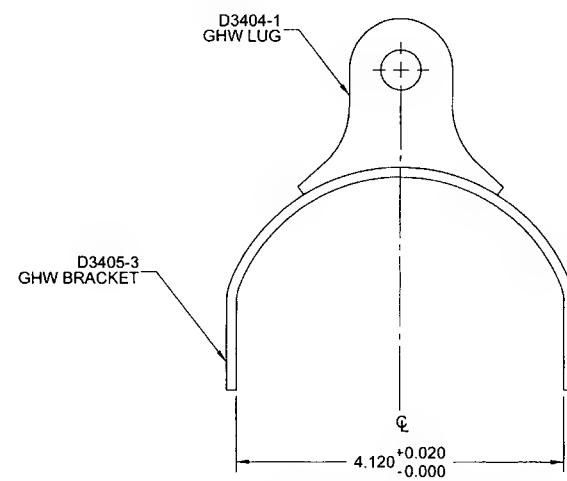
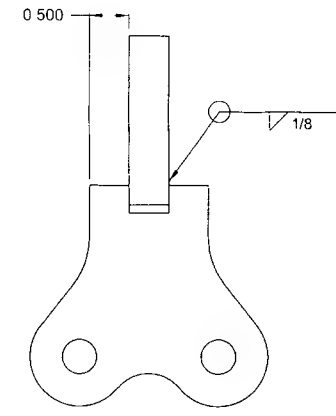
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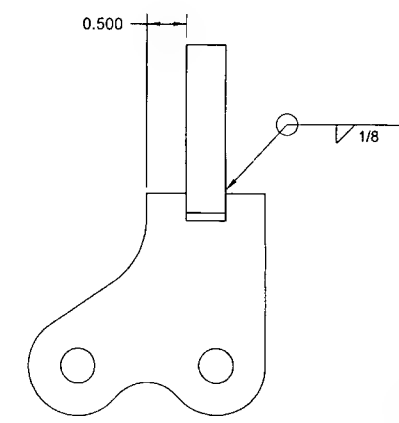
84941



D3405-041 LUG ASSEMBLY



D3405-043 LUG ASSEMBLY



RELEASED
06/12/18

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO	REV. B
MFG APPR		D3405	SHEET 2 OF 4
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DE APPR.		GHW LUG ASSEMBLY	NTS
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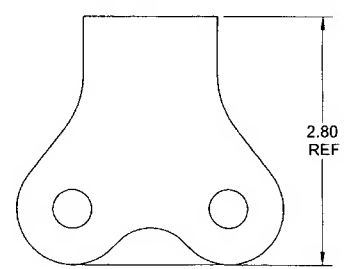
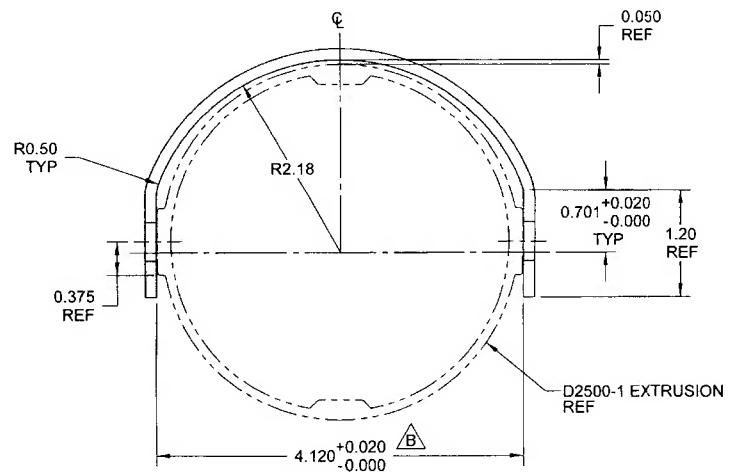
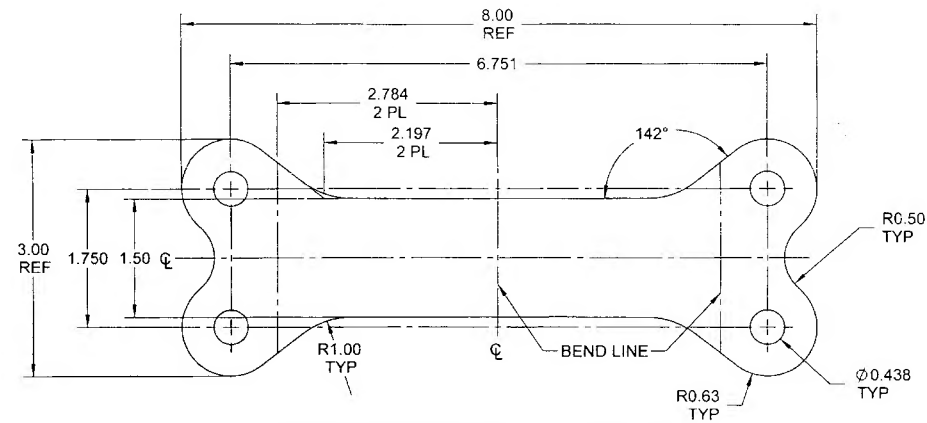
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84941



SIDE VIEW FOR REF ONLY

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B SHEET 3 OF 4
MFG. APPR.		TITLE GHW LUG ASSEMBLY	SCALE NTS
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DE APPR.			
DATE	08.09.19		

RELEASED
07/08/12/13

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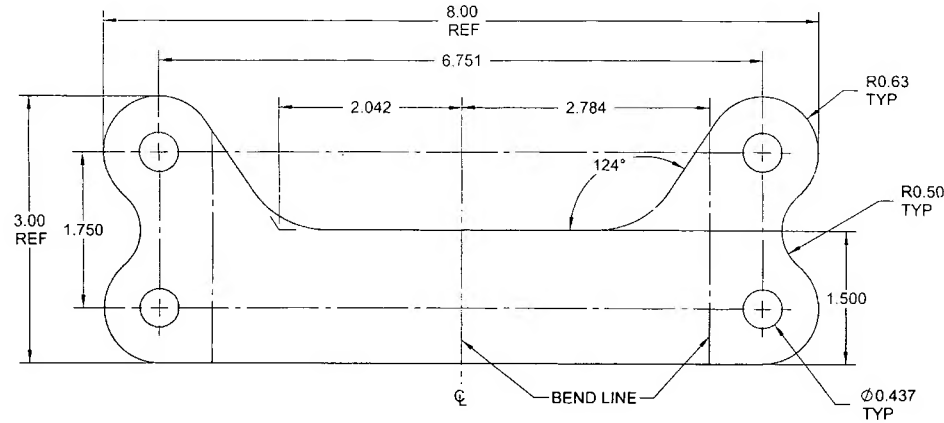
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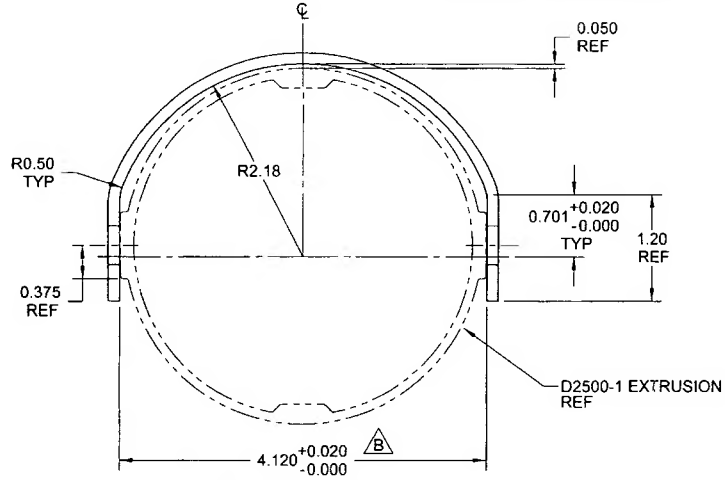
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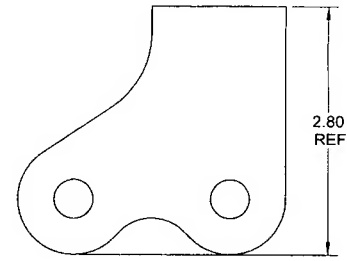
84941



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

RELEASED
08/12/18

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REF. DART SPEC. M304S11GA
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 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

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CHECKED		DRAWING NO. D3405	REV. B SHEET 4 OF 4
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